

48

Date: Monday, 10/22/2007 3:59:44 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
Job Number : 35306
Estimate Number : 10973
P.O. Number : N/A Part Number : D206667203B
This Issue : 10/22/2007 S.O. No. : N/A Drawing Number : D206-667-243 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : N/A
Previous Run : 34483 Material : N/A
Written By : Due Date : 11/30/2007 Qty: 1 Um: Each
Checked & Approved By : 07.10.23
Comment : Est Rev:F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

2.0 D6004115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube B32305

Check OD = 2.500"; ID = 1.800"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:59:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243
Inside of Cuff(Donot engrave on outside of tube)

mk 07/11/01

①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

mk 07/11/01

①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/11/05

①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

AWN 07-11-08

1-Polish entire outside surface of crosstube

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 07/11/08

①

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWN 07-11-08

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

JA-11-12 (1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 7-11-14

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JA-11-15 (1)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JD 7-11-15 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:59:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5068

C20711/190

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C20711/190

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

NFA

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

20711-190

20.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

34077

ml 07 11 20

21.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422

ml 07 11 20

22.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

104885

ml 07 11 20

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



(P15) →

Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

ml 07 11 20

①

24.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube ~~DEL FLEET BLUE~~

4-CLEAR WITH ~~DEL FLEET~~

white
Imron

ml 07 11 21 ①

ISSUE P.O TO ATELIER DEBOSSSELAGE

25.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

RT 07-11-22

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s)

Pick:

Qty Part number Description Batch

2 D2856-400(Cut to 7.73") Abrasion Strip

34642

RT 07-11-23

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1 Support

34063

RT 07-11-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/23	# 830	one Nut plate was installed incorrectly. it was installed too high. R.C. Hummer error	<i>[Signature]</i>	Drill out Nuts and replace with new ones. MS2064 AD4410 Bd 104885	<i>[Signature]</i> 07-11-23	<i>[Signature]</i> 07/11/27	<i>[Signature]</i> 07/11/27	<i>[Signature]</i> 07/11/27
				towel up heads of Rivets with white Emson Pat AS PER QSI 005	<i>[Signature]</i> 07/11-27	<i>[Signature]</i> Hub27		

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:59:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203B1

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105799

RT 07-11-23

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. .Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

RT 07-11-23

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/16/27 (41)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

1105408

SP

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

1105430

SP

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

110415B1

7/16/27 SP (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 35306

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

10 AN5-10A

Bolt

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

4 AN5-32A

Bolt

M104936

SC

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:Packing Kit

Qty Part number

Description Batch

18 AN960JD516

Washer

M10415L

7/11/27 SC (A)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

B

AS 07/11/27

202

(X)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27

Job Completion



11/07/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35306
Description: Crosstube Assembly		Part Number:	D206-667-243
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.490	+0.005/-0.000	2.495	—			
	2.018	+0.005/-0.000	2.023	—			
	2.079	+0.005/-0.000	2.084	—			
	2.145	+0.005/-0.000	2.150	—			
	2.209	+0.005/-0.000	2.214	—			
	2.287	+0.005/-0.000	2.290	—			
	2.363	+0.005/-0.000	2.364	✓			
	2.433	+0.005/-0.000	2.436	—			
	0.200	+/-0.010	0.200	—			
	0.500 x 30°	+/-0.010	0.500x36°	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.438	+/-0.030	4.438	—			
SIDE B	104.91	+/-0.020	104.920	—			
	2.490	+0.005/-0.000	2.492	✓			
	2.018	+0.005/-0.000	2.023	—			
	2.079	+0.005/-0.000	2.084	—			
	2.145	+0.005/-0.000	2.150	—			
	2.209	+0.005/-0.000	2.214	—			
	2.287	+0.005/-0.000	2.290	—			
	2.363	+0.005/-0.000	2.365	—			
	2.433	+0.005/-0.000	2.435	—			
	0.200	+/-0.010	0.200	—			
	0.500 x 30°	+/-0.010	0.500x36°	—			
	R0.063	+/-0.010	R0.063	—			
	R0.500	+/-0.010	R0.500	—			
	4.438	+/-0.030	4.435	—			

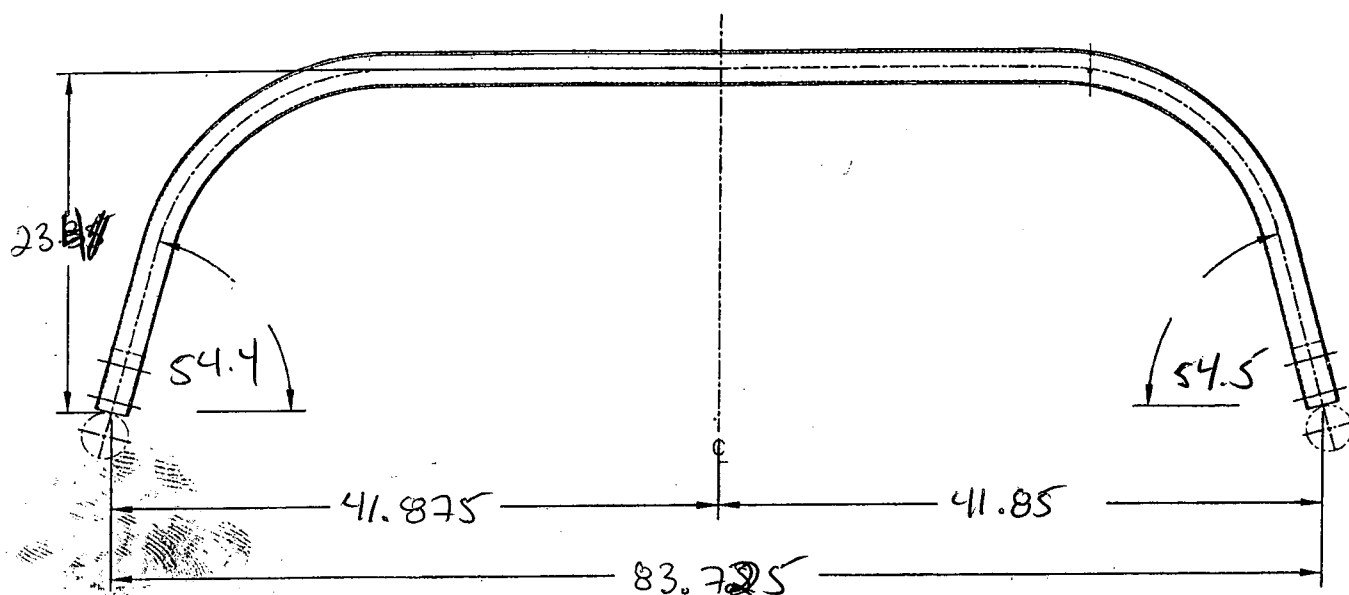
Measured by:	Qnd	Audited by:	J.F.	Prototype Approval:	N/A
Date:	07/11/02	Date:	07/11/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue (P/O D206-667-203)	KJ/JLM	



DART AEROSPACE LTD		Work Order:	35306
Description: Crosstube High Aft (206L)		Part Number:	D206-667-203
Inspection Dwg: D206-667-243 Rev: B		Page 1 of 1	

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	41.86	41.98
Angle	54	56
Total Span	83.72	83.96



Comments

QC15 Inspection	
Date	7.11.12

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE NTS
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26 - #

UNDER REVIEW

06.07.10 RH

12.07.09 detail F

RH

07.05.02

Qty	Part Number	Description
X	D206-667-243	CROSSTUBE ASSEMBLY
1	D6004-115	CROSSTUBE
2	D2856-400-773	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2892-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-22	CLAMP

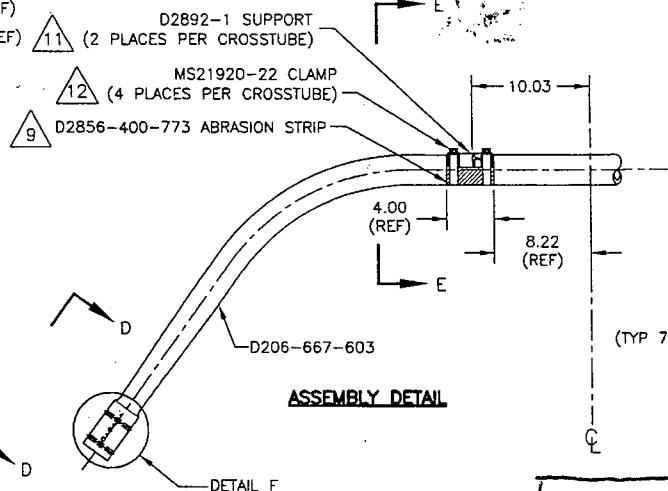
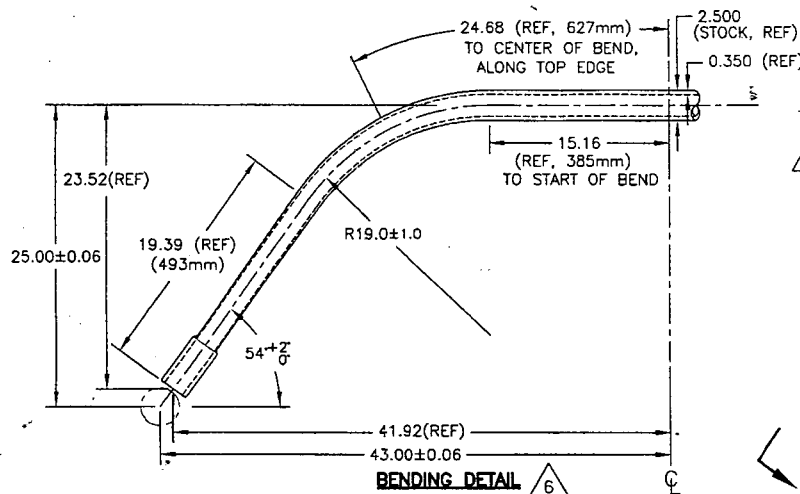
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35306

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B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

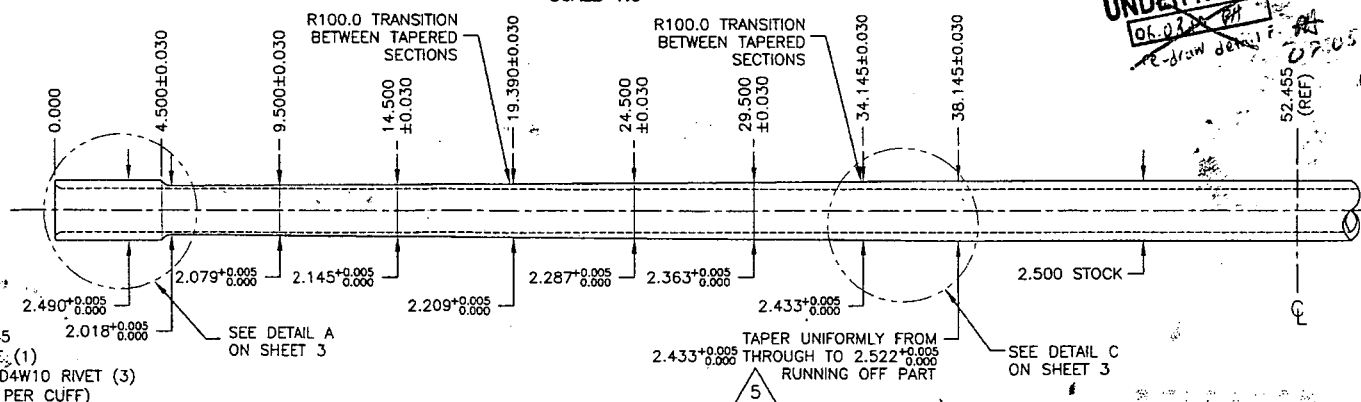
PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 100$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

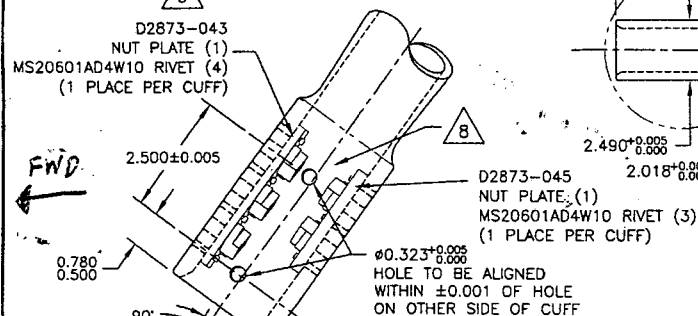
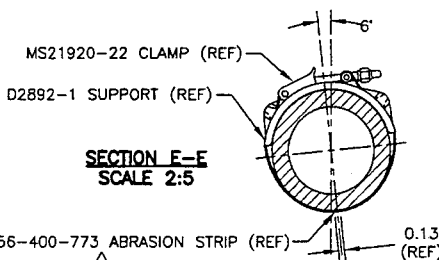
UNDER REVIEW
06.02.04 PH
RE-Draw detail F
07.05.02

TURNING DETAIL
SCALE 1:5



SEE DETAIL C
ON SHEET 3

SECTION E-E
SCALE 2:5



VIEW D-D:
CUFF DETAIL
SCALE 2:5

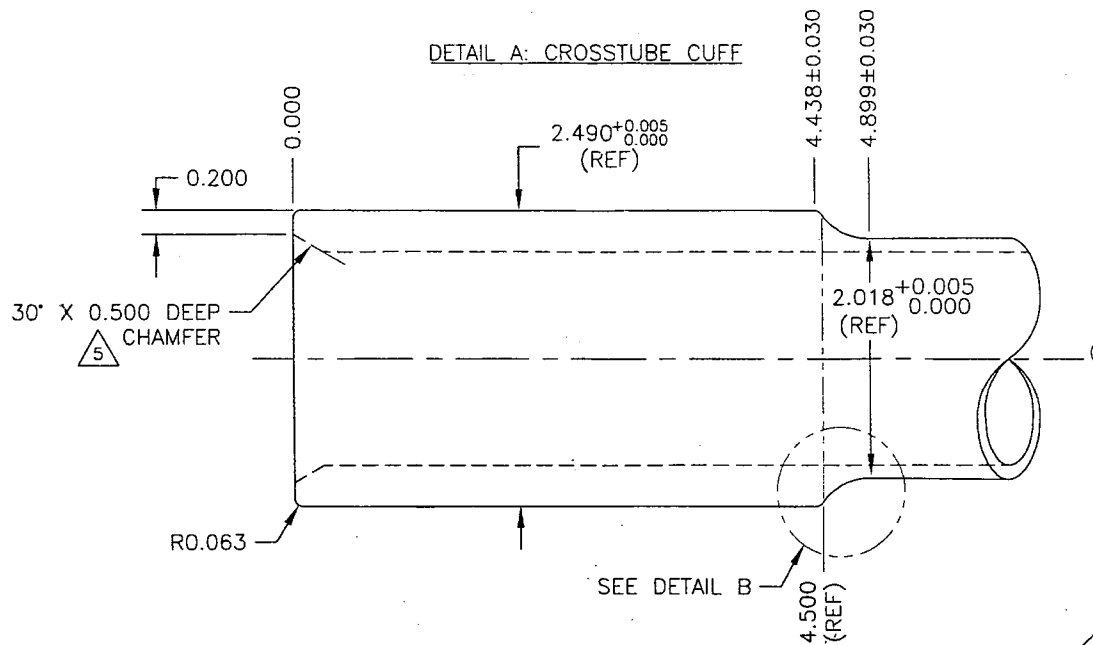
NO. 35304
WORK ORDER
SUBJECT TO AMENDMENT
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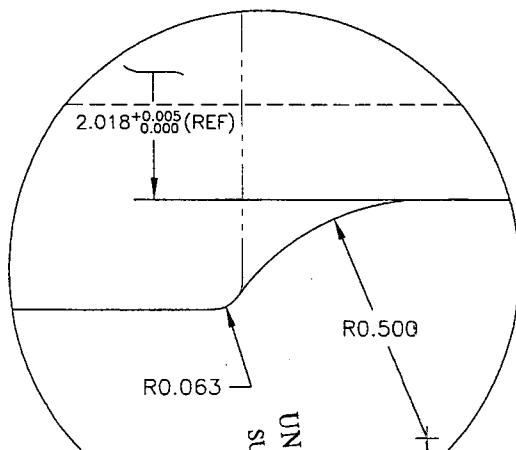
DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
PH	PH		WARRICKSBURY, OXFORD, CANADA
CHECKED # DS	APPROVED # DS	DRAWING NO. D206-667-243	REV. B SHEET 2 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)	SCALE 1:10

DETAIL A: CROSSTUBE CUFF

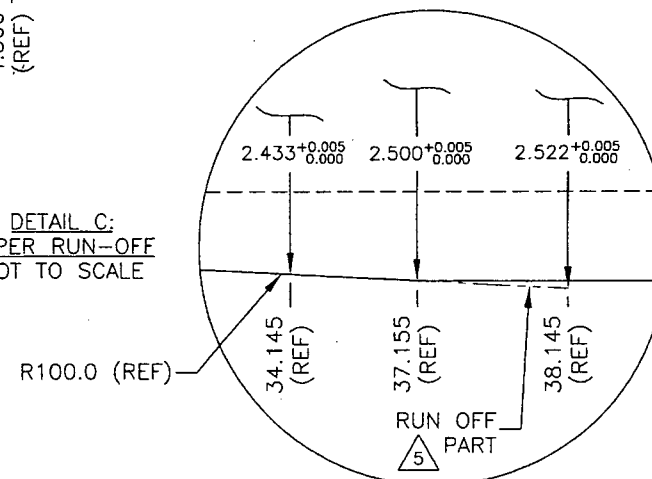


05.07.26
UNDER REVIEW
 06.05.06 PH
 re-draw detail if
 PH 07.05.02

DETAIL B: CUFF TRANSITION SCALE 4:1



DETAIL C: TAPER RUN-OFF NOT TO SCALE



NO. 35306
 WORK ORDER
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED DS	APPROVED DS	DRAWING NO. D206-667-243	REV. B SHEET 3 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH AFT)		SCALE 1:1	



LIQUID PENETRANT TEST REPORT

P - 1200 1

PAGE 1 OF 2

CLIENT	DART AEROSPACE	DATE	NOV 16 2007	TIME	AM <input type="checkbox"/> PM <input type="checkbox"/>
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 07 1200		
ADDRESS	1270 ABERDEEN ST	PO/NO.	5068		
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY		
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005
PROJECT	OH 58 FWD/AFT, 206LFWD/AFT, 407 HIGH AFT X TUBES				
ITEM(S) EXAMINED	JOB #S OH 58: 33146,33147,33148,33152,35532,35533,35534,35535. JOB#S 407: 33327				
	JOB #S 206L: 35043,35305,35306.				

JOB DESCRIPTION	PROCEDURE NO. LT-0002 REV./DATE	TECHNIQUE NO. LT-TECH2 REV./DATE
PART NO. D206667203/D206667103BL/D05876101,201/D407667205	MATERIAL ALODINED ALUM.	THICKNESS
SCOPE WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE		

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL SEP 18 07	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input checked="" type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- (☐ METRIC ☒ IMPERIAL)

FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL SURFACE ON:

206L FWD X TUBES JOB#s 35305
206L AFT X TUBES JOB#s: 35043,35306
OH58 FWD X TUBES JOB#s:33146,33147,33148,35532
OH58 AFT X TUBES JOB#s: 33152,35533,35534,35535
407 HIGH AFT TUBE JOB#: 33327

RESULTS: NO INDICATION OF DEFECTS.
ITEMS ACCEPTABLE TO STANDARD.

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E27347
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:
NAME (PRINT):	JASON HEWETT	NAME INITIALS
	1 ST TECHNICIAN	2 ND TECHNICIAN
	CGSB LEVEL 2 SNT LEVEL	CGSB LEVEL SNT LEVEL
	CGSB REG. NO 6156	CGSB REG. NO

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